











Date: Friday, 4/21/2006 10:12:22 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 205 SKIDTUBE "I" BEAM
Job Number	: 26750		
Estimate Number	: 10346		
P.O. Number	: N/A	Part Number	: D2596
This Issue	: 4/21/2006 S.O. No. : N/A	Drawing Number	: D2596 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: C
Previous Run	: 26298	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 4/28/2006
Checked & Approved By	: <u>SEE ABOVE USER & DATE</u>	Qty:	13 <u>DP</u>
Comment	: Est: D 99.02.02 Changed QA to QC, Added Step 6 and Cost D M	Um:	45 Each

Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
1.0	D25003100	Ext'n - I" Beam Web 4"
<div><div></div><div></div></div>		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 15.0000 Each(s) Extrusion "I" Beam Web 4" Pick; Qty Part Number Description Batch 1 D2500-3-100 Extrusion BT 06-04-21 (13)		
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
<div><div></div><div></div></div>		
Comment: LANDING GEAR RESOURCE 1 1- Cut D2500-3-100 to length: 99.5" IT 06-04-20 (13) 2- Use Jig DT8093 to drill pilot holes #30 RT 06-04-24 (13) 3- Open to 0.625" diameter using a uni-bit IT 06-04-24 (13) 4- Deburr IT 06-04-25 (13)		
3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<div><div></div><div></div></div>		
Comment: HAND FINISHING RESOURCE #1 Acid Etch and Alodine per QSI 005 4.1 IT 06-05-04 (13)		
4.0	QC5	INSPECT WORK TO CURRENT STEP
<div><div></div><div></div></div>		
Comment: INSPECT WORK TO CURRENT STEP BE 06-05-04 (13)		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
<div><div></div><div></div></div>		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: PG IT 06-05-04 (13)		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *LD* Date: 06/05/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0


DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

 26/05/05 (13)

Job Completion



u 06-05-05

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

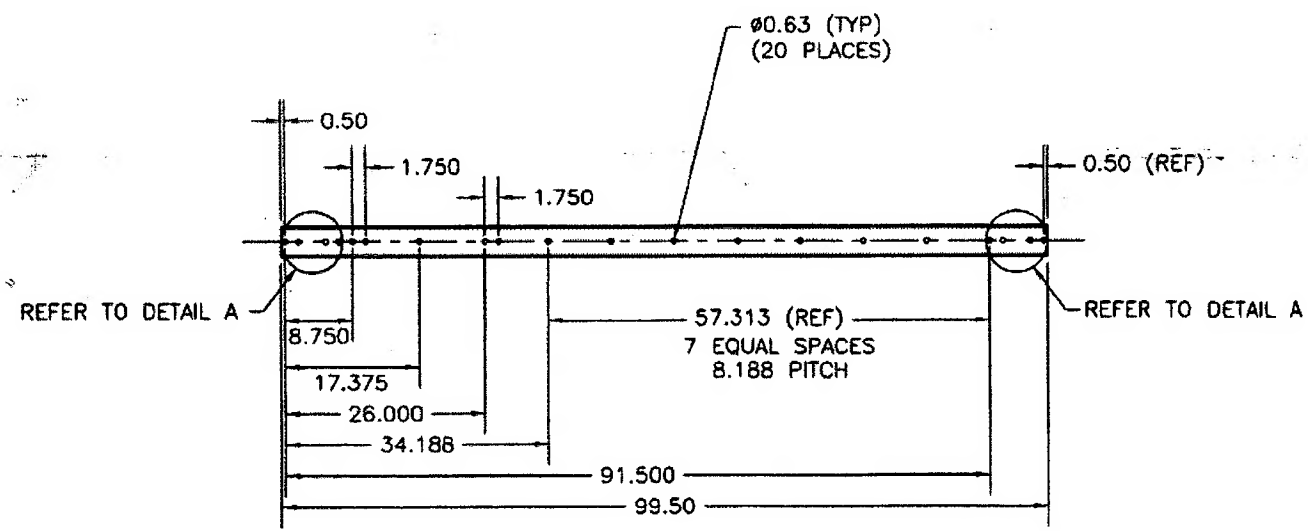
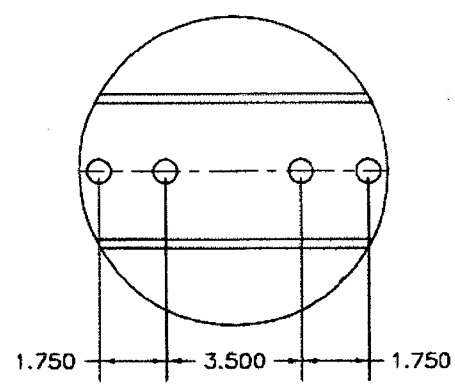
DART



RELEASED
98.09.17 bs

REFERENCE ONLY

DETAIL A
SCALE 5:24



REFER TO DETAIL A

REFER TO DETAIL A

DESIGN	<i>[Signature]</i>	DRAWN BY	<i>[Signature]</i>	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	REV. C
DATE	98.09.14	TITLE	D2596	SHEET 1 OF 1
			205 WEB	SCALE 1:24
A	96.09.16	NEW ISSUE		
B	97.07.23	0.63 HOLE WAS 0.56		
C	98.09.14	INCORPORATED DEO 9097		

MANUFACTURED FROM D2500-3 EXTRUSION
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED